Shep Tues April 8

# Work Order ID 115081

Monday, March 17, 2014 2:42:36 PM

\*115081\*

Page 1

Item ID: Revision ID: Item Name:	D3575-2 Cargo Floor P	rotector		Accept	*N900	<u>0</u> 40	100	)* ፡	Setup Sta	171	S1* S2*
Start Date: Required Date:	3/17/14 3/17/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I	ID:					( )/
Reference:			•		1						
Approvals:	Process Pla	n: ML5	Date: 14-03-	19 Tooling:	D	ate:		I	Run Sta	~1 <i>\</i> J	R1*
	QC:		_ Date:	SPC (Y/N):	D	ate:			Sto	<sub>ь</sub> *И	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			- +						
D3575	Rev	A			I						
100				0.00	:						
*100* Waterjet		FLOW WATER JET  Memo		0.00	İ			1_	٥		Jm14.04-8
FLOW CNC Waterj	jet		URE SIDE UP*** or Dwg D3575		;						
		Dwg Rev:_	1		İ						
		Prog Rev:_									
		2-Deburr	<i>P</i>								
					i						
110		QC2- Inspect parts off r	machine FAI/FAIB	0.00	ļ						_
<b>*110*</b> qc		Мето		0.00	I			1	0		Jm14-04-8
Quality Control					!						

DQA:	Date: WORK ORDER NON-CONFORMANCE / UPDATE													DART
QA Closed:			Date:			WORK ORDER NON	-((	JNFOI	RIVIANCE / C		ork Order up	odate only	Γ	AERŌSPĀCĒ
Mank Ond				•		DISPOSITION								
Work Ord	er:			<del> </del>		Rework	1	Skid-tube Crosstub			Water Jet			Engineering
Part f	No.	D		Scrap		ı	Machining	Small Fab	Prod. Eng. Coor.			Quality		
NCR I	NCR No.				Use-as-is			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	_	Other	
Root					Desc	ription of work order update		nitial	Ad	ction	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verificatio	n	QC Inspector
Design														
Doc/Data	<u> </u>													
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup	-													
Process									·					
Supplier Training	H													
Transport	_										1			
Unapproved	$\vdash$	1												
	1	l	<u> </u>	I			FA	ULT CA1	EGORY		<u>.</u>	<u> </u>		
Landi	ng (	Gear				General					·····		_	
	_	Bending				Bend	Г	]Folio/P	rogram		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under			Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re	F	Part Incorre			Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/U	Unqualified	Part Lost/Mi			Weld
		Cuffs				Contamination	Г	1	ions Incomplete	· —	Part Moved	_		Wrong Stock Pulled
ļ		Crushing				Countersink		4	ned/off center	_	Positioned V	Vrong	_	
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misread	1	<u> </u>	<del>1</del>			
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of 0	Calibration					700 To 100
		Wave/Tw	ist in Tub	е		Fit/Function		Out of 9	Sequence					

Work Order ID 115081 \*115081\* Page 2 Monday, March 17, 2014 2:42:37 PM Accept D3575-2 Item ID: \*N900040100\* Setup Start **Revision ID:** Stop Cargo Floor Protector **Item Name:** \*1\* Start Otv: 1.00 **Start Date:** 3/17/14 **Custiltem ID:** Required Date: 3/17/14 Reg'd Otv: 1.00 \*1\* Customer: Reference: Run Start Process Plan: Date: Tooling: **Approvals:** Date: Stop OC: Date: SPC (Y/N): Date: NIR9\* Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Run Hours Oty Oty Number Stamp Code 120 OC8- Inspect parts - second check 0.00 \*120\* Memo Quality Control POP1150860.00 Identify as per dwg & Stock Location: 150 14/1/8 (1)

160

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

\*160\* QC

\*150\* Packaging

Packaging

Memo Quality Control

0.00

M15 14-04-08

WW04.08

DQA:		Date:												
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UF		Wc	ork Order up	odate only	$\neg$	AEROSPACE
					DISPOSITION			· .			<del></del>	· · · · · · · · · · · · · · · · · · ·		
Work Orde	er:				DISPOSITION	AGAINST DEPARTMENT/PROCESS								
					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo				Scrap			Machining	Small Fab				_	Quality
NICD N	NCR No.				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	_	Rec/Sto	e/Packaging	$\dashv$	Other
NCK				<del></del>	Suspected Onapproved	j		Large Fab	Composite[			Supplier	_	
Root				Desc	ription of work order update		Initial	Acti	ion		Sign &		Т	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	1	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre													Ì	
Material														
Operator														
Offset/Setup														
Process														
Supplier						ŀ								
Training													1	
Transport		Ì												
Unapproved													$\perp$	
						FA	ULT CA	TEGORY						
Landi	ng Gear			_	General		-				•	_		
	Bendir	ng			Bend		Folio/F	Program	ļ		Outside Dim	ensions	'	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain		ļ		Over/Under	tolerance	!	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ા _	_ -	Temperature/Cure
	Crimp,	Kink/Ripple	e/Wave	L	Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	ىل_	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear		Part Moved		'·	Wrong Stock Pulled
	Crushi	ng			Countersink		Misalig	ned/off center	į		Positioned V	Vrong		
	Heat T	reat			Cut Too Short		Mislabe	eled			Power Loss/	Surge	<u> </u> 6	Other
	Inspec	tion Strip ir	n Tube		Drawing		Misread	d						
	Marks	/Chatter			Drill Holes		Off-set							
	Turnin	g Sequence	9		Finish		Out of	Calibration						
	Wave/Twist in Tube				Fit/Function		Out of	Sequence						

**Picklist Print** 

Monday, March 17, 2014 2:42:36 PM

Work Order ID: 115081

\*115081\*

Parent Item:

D3575-2

\*D3575-2\*

Parent Item Name: Cargo Floor Protector

**Start Date:** 3/17/14

Required Date: 3/17/14

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev : A New Issue 07-01-22

Component Item ID/
Item Name

Replacement Mfg/

Bin Primary Item Location Last Location **Route** Seq ID Unit of Qty on Measure Hand

\*\*

Qty per Kit Total Qty

(10)

Date Issued **Issued** 

Status

Page 1

MLEXS.125-F60029-04

Purchased

Purch

No

100

sf

1,964.990

Qty

m14-04-8

\*MI FXS 125-F60029-04\*

Item ID

GE PLASTICS LEXAN SHEET

<b>Location</b>	Loc Qty	Loc Code
MAT019	1964.99	
124866	106	
m126425	467.99	
m127934	1391	
	i	

<u>de</u>

127934.

DQA:			Date:											$^{\sim}$ aar
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
	•					Rework	١		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	No.					Scrap			Machining Small Fab			d. Eng. Coor.	╗	Quality
	· · ·				Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other	
NCR No.				Suspected Unapproved			Large Fab	Composite	]	Supplier				
Root					Desc	ription of work order update		nitial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	1	QC Inspector
Design														
Doc/Data							Ì							
Equip/Tooling					ļ									
Handling/Pre														
Material														
Operator														
Offset/Setup	Ш													
Process	Ш											į		
Supplier			1											
Training	Щ		1											
Transport														
Unapproved							<u> </u>							
<del>,</del>					,		FA	ULT CA	TEGORY					
Landi	ng (					General		1 .		_	7	-		
		Bending				Bend		4	Program		Outside Dim	H-		Pressure/Forced
		Centre No	ot Concer	ntric	L	BOM/Route	<u> </u>	Grain			Over/Under	F		Set-up
		Cracks				Broken/Damage/Defect	L	Hardwa		<u></u>	Part Incorre	ŀ		Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple	e/Wave	<u> </u>	Burrs		<b>i</b>	ion Incomplete/Un	· —	Part Lost/Mi	-		Weld
	Ш	Cuffs			<u> </u>	Contamination	<u> </u>	4	tions Incomplete/U	Inclear	Part Moved			Wrong Stock Pulled
	$\vdash$	Crushing			<u> </u>	Countersink	<u> </u>	1 1	gned/off center	<u> </u>	Positioned V			
	<u> </u>	Heat Trea			ļ	Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge		Other
	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Inspectio	•	Tube	_	Drawing		Misrea						
	$oxed{oxed}$	Marks/Ch			<u> </u>	Drill Holes	$\vdash$	Off-set						· · · · · · · · · · · · · · · · · · ·
	$oxed{oxed}$	Turning S				Finish	<u></u>	4	Calibration					
	1	Wave/Tw	ist in Tul	эе		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	115081
Description: Cabin Floor Protector	Part Number:	D3575-2
Inspection Dwg: D3575 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

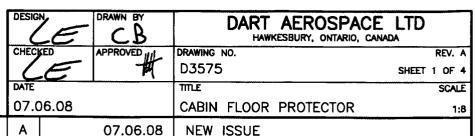
X First Article Prototype

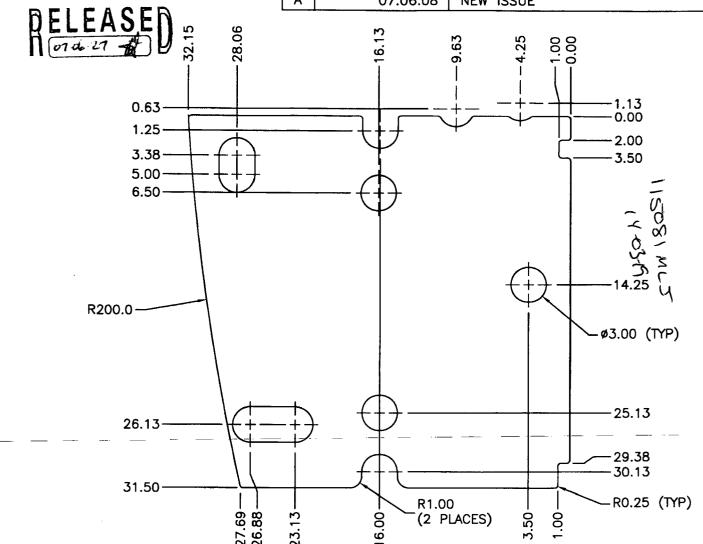
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	_		V	Jkmos
1.00	+/-0.030	1.00	_		ν	
3.50	+/-0.030	3.95	_		ν	
16.00	+/-0.030	16000	_		T	Jhmos
23.13	+/-0.030	23.13			т	
26.88	+/-0.030	26.88"	_		T T	
27.69	+/-0.030	27.69"	_		T	
4.25	+/-0.030	4.25			ν	
9.63	+/-0.030	9.63			V	Jamo8
16.13	+/-0.030	16434	_		T	
28.06	+/-0.030	25.06	_		-	
32.15	+/-0.030	32.15"	_		Т	
2.00	+/-0.030	2.00h	_		V	
3.50	+/-0.030	<u>_3-50"</u> _			- <b>∀</b>	
14.25	+/-0.030	14.25	_		一	
25.13	+/-0.030	25.13	_		-	
29.38	+/-0.030	29.38	_		丁	
30.13	+/-0.030	30.134	_		T	
1.25	+/-0.030	1.25h	_		<b>V</b>	
3.38	+/-0.030	3.382	_		V	
5.00	+/-0.030	5.00m			V	
6.50	+/-0.030	6.50h			ν	_
26.13	+/-0.030	24.134				
31.50	+/-0.030	31.50	DAS		7	

Measured by:	Jm	Audited by:	27 . h-89 <i>i</i>	Prototype Approval:	N/A
Date:	14-04-8.	Date:	14/4/8	Date:	N/A

Re	v Date	Change	Revised by∧	Approved
Α	08.02.29	New Issue	KJ/DD 🛠	







# D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

#### NOTES:

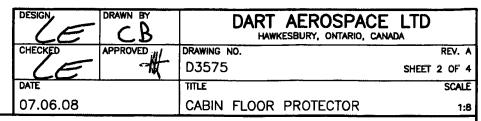
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

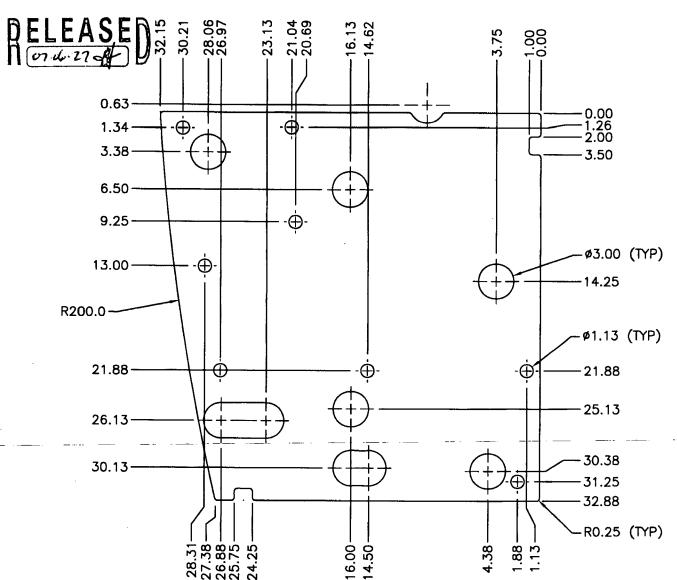
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#### D3575-3 CABIN FLOOR PROTECTOR

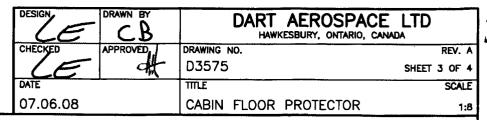
#### NOTES:

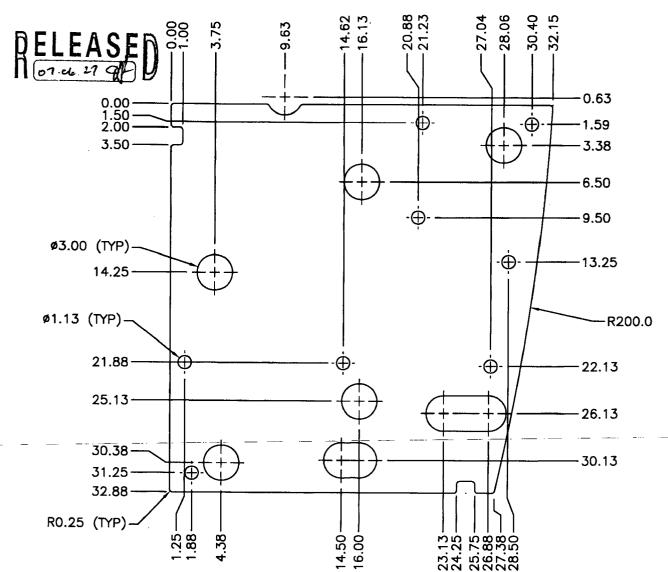
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

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### D3575-4 CABIN FLOOR PROTECTOR

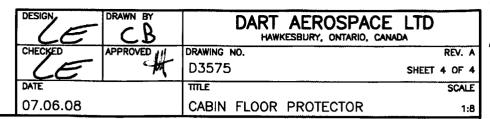
#### **NOTES:**

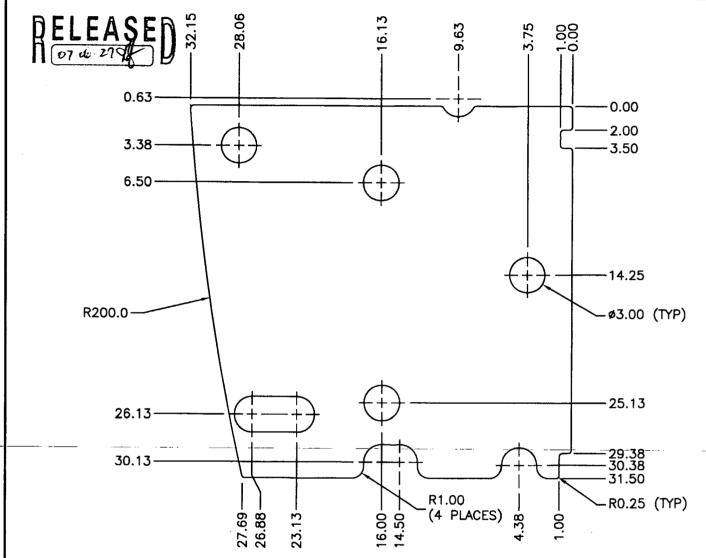
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

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## D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

#### NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE). 0.125 THICK. TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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